

Date: Thursday, 12/14/2006 3:40:18 PM
 User: Kim Johnston

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : LONG STEP ASSEMBLY HIGH SKID LH |
| Job Number : 29967 | |
| Estimate Number : 10270 | |
| P.O. Number : N/A | Part Number : D350591311 |
| This Issue : 12/14/2006 S.O. No. : N/A | Drawing Number : D3272 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : LARGE FAB ASSY | Drawing Revision : A |
| Previous Run : 29800 | Material : N/A |
| Written By : <u>[Signature]</u> | Due Date : 1/12/2007 Qty: 10 Um: Each |
| Checked & Approved By : <u>[Signature]</u> 06 12 15 | |
| Comment : Est Rev: 04.03.22 New issue KJ/RF | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

KS 06.12.18

| | | |
|-----|-----------|-----------|
| 2.0 | D2622120C | Extrusion |
|-----|-----------|-----------|

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2622-120

Extrusion

B28215

FF 07-01-09 10

| | | |
|-----|-------------|------------------------------|
| 3.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|

**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

FF 07-01-09 10

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|

**Comment:** INSPECT WORK TO CURRENT STEP

FF 07-01-09 10

| | | |
|-----|--------|-----------|
| 5.0 | D30671 | End Plate |
|-----|--------|-----------|

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 29967

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3067-1

End Plate

329356

PE 07-01-09

10

6.0

D32191

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3219-1

Support

329751

PE 07-01-09

10

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

PE 07-01-09

10

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *M190237 M19612*

PE 07-01-10

10

3-Grind End Plate flush

PE 07-01-10 (5) FF 07-01-10 (5)

10

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PE 07/01/10 (10)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PE 07/01/10 (10)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



yd/a.m 07-01-10



(10)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PE 07-01-10

10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Job Number: 29967

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D3065041

Step Leg Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3065-041

Step Leg Assy

328738

PE. 07-01-10

10

13.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3066-1

Spacer

329609 = 8
328269 = 12

PE. 07-01-10

10

14.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W4

Rivet

1101649

PE. 07-01-10

10

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

Leave one rivet out until welding is complete.

PE. 07-01-10

10

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-01-11

17.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3067-1

End Plate

329356

PE. 07-01-11

10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 29967

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *M19612*

4-Grind End Plate flush

5-Install last rivet as per Dwg.

J.E. 07-01-11 10

J.E. 07-01-11 10

J.E. 07-01-11 10

J.E. 07-01-11 ⑤ FF 07-01-11 ⑤ 10

J.E. 07-01-11 10

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/01/11 ⑩

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/11 ⑩

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

touch up alodine

LLS / M

07/01/11 ⑩

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

102391

FL/YL

07/01/11 ⑩

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

FL/YL

07/01/11 ⑩

WORK ORDER CHANGES

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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WORK ORDER NON-CONFORMANCE (NCR)

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 29967

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

26.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2230-3 Mounting Lug

B 29646 x 8 / B 29645 x 82 ✓

27.0

D2618

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2618 Bushing

B 28248 x 7 / B 29645 x 13

28.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 6.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2856-400-720 Abrasion Strip

B 29285 ✓

29.0

D32351

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

-2 D3235-1 Mounting Lug

B 29357 x 4 / B 29824 x 16 ✓

30.0

D3278041

Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3278-041 Support Assembly

B 30150 ✓

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Date: Thursday, 12/14/2006 3:40:19 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 29967

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3272-041(ref) Step Assembly B29967 ✓

31.0

AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A Bolt m102339 ✓

32.0

AN413A

Bolt,



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-13A Bolt m100188 ✓

33.0

AN536A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-36A Bolt m102602 x19 / m102971 x1 ✓

34.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10 Washer m100743 ✓

35.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416 Washer m101938 ✓

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Date: Thursday, 12/14/2006 3:40:19 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 29967

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516 Washer m100564 ✓

37.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3 ✓ Nut (or -3) m101917 x 16 / m102217 x 4 ✓

38.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 ✓ Nut (or -4) m19185 ✓

39.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5 ✓ Nut (or -5) m102171 ✓

C 207101/12 (10)

40.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C 2101/12 (10)

41.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-311

Location: DEUB

C 2101/12 (10)
C 2101/12 (10)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: PD Date: 07/01/12
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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Date: Thursday, 12/14/2006 3:40:19 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 29967

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10
207/0/12

Job Completion



U 07201-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries



| | | | |
|---------------------|-----------------------|--|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>#</i> | APPROVED <i>#</i> | DRAWING NO. D3272 | REV. A SHEET 1 OF 2 |
| DATE 04.03.01 | | TITLE STEP ASSEMBLY, HI LONG | SCALE NTS |
| A | 04.03.01 | NEW ISSUE | |

RELEASED
04.04.05 *#*

| Part No. | Description | QTY -041 | QTY -042 |
|--------------|-------------------------------|-------------|-------------|
| D3272-041 | Step Assembly, High Long (LH) | X | |
| D3272-042 | Step Assembly, High Long (RH) | | X |
| D2622-120 | STEP EXTRUSION | 1 | 1 |
| D3219-1 | SUPPORT | 2 | 2 |
| D3065-041 | LEG ASSEMBLY | 1 | 1 |
| D3066-1 | SPACER | 2 | 2 |
| D3067-1 | END PLATE | 2 | 2 |
| MS20600AD4W4 | RIVET | 16 | 16 |

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29967

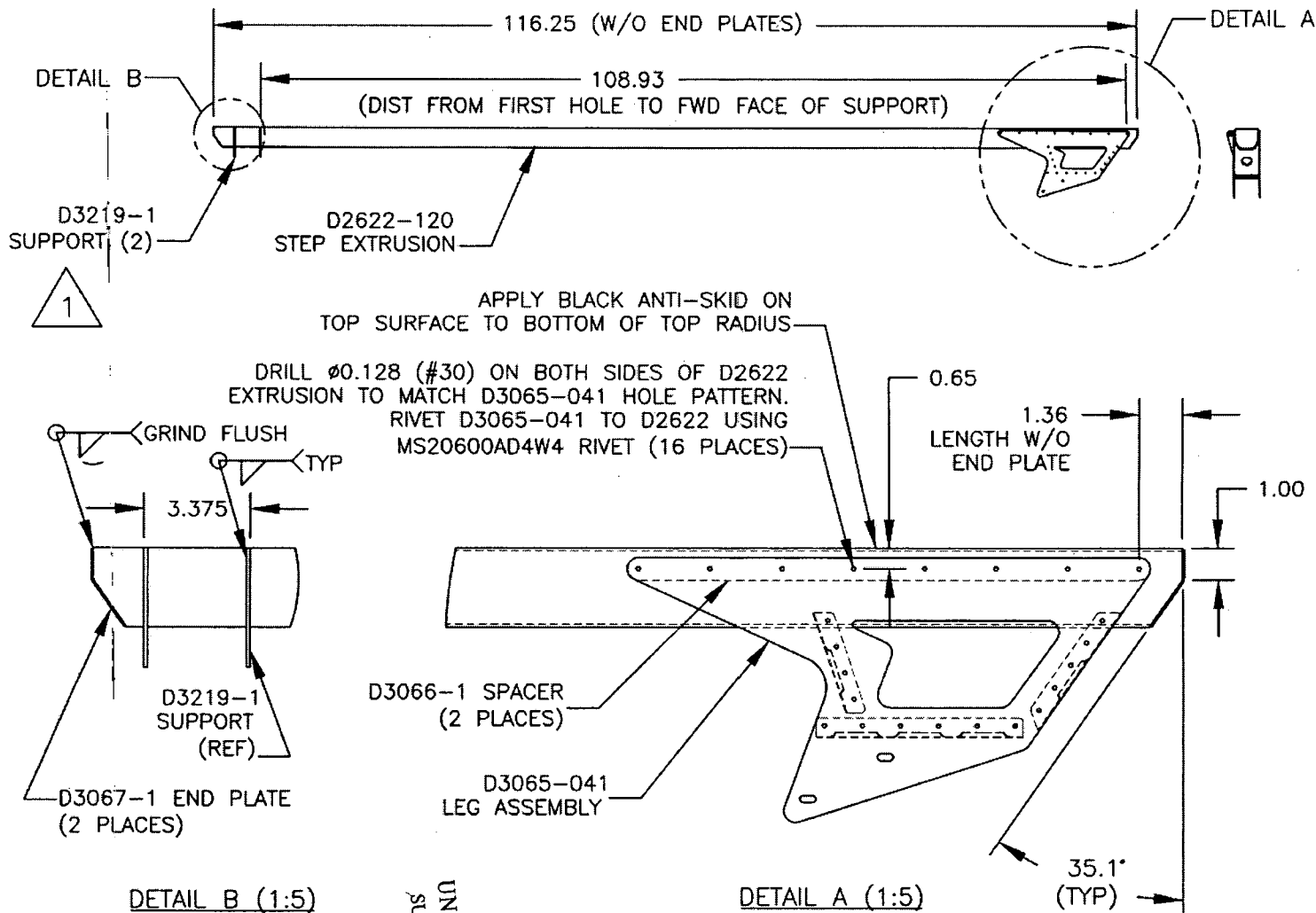
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DART



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|------------------------|----------|----------|-------|---|--------|
| DESIGN | AP | DRAWN BY | AP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AP | APPROVED | AP | DRAWING NO. | REV. A |
| DATE | 04.03.01 | TITLE | D3272 | SHEET 2 OF 2 | SCALE |
| STEP ASSEMBLY, HI LONG | | | | 1:20 | |



DETAIL B (1:5)

DETAIL A (1:5)

RELEASED
04.04.05

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